

## StyleLite® Lamination Guide

### APPLICATIONS

StyleLite® can be laminated in a variety of ways to create panels suitable for cabinet doors, drawer fronts and general domestic and commercial furniture applications.

### DOORS & PANELS

StyleLite laminated to MDF is for interior applications only. A maximum finished panel size of 4' x 10' is recommended.

### SPECIFICATIONS

StyleLite laminated panels must be suitably balanced on the reverse side of the substrate. Substrates can include MDF, HDF, Plywood or composite boards.

### LAMINATION MATERIALS & PROCESS

**StyleLite** – 0.8mm & 1.0mm for auto lamination. 1.0mm will produce satisfactory results for hand lamination.

**Substrate** – use select grade smooth sanded moisture resistant MDF 5/8" or thicker. 240 grit sandpaper will provide the best finish results.

**Backing panel** – for single sided applications using unfinished MDF, adhere 0.8mm thick cabinet liner, HIPS or ABS liner to rear surface of the substrate.

**Hand Lamination** – Water based EVA, liquid PUR'S and water based contacts are suitable. Apply via spray, roller or notched trowel. Ensure adhesive is applied evenly. Two sided application provides a stronger bond. Follow adhesive manufacturer's instructions.

StyleLite can be laminated in a variety of ways to add a touch of style to your interior

**Automated Lamination** – PUR other hotmelt and water based EVA systems are suitable. Using an even and light to moderate adhesive build, will achieve the optimum visual appearance.

**Pressing** – Ensure StyleLite and substrate are clean and free of dirt and debris before lamination. Light to moderate cold press only. Hot pressing StyleLite may induce excessive bow in the finished panel. Block stack for 24hours after pressing.

**Edge Banding** – Use ABS, Acrylic or Poly Propylene edge banding secured with EVA or PUR hot melt adhesives. Heat activated edge band also applicable.

**Curved Panels** – StyleLite laminated panels can be formed into curves by curving the rear of the substrate, or curve the substrate first and then bond StyleLite to the substrate using a water based contact adhesive.

Lamination should only be completed between 60°F to 85°F ambient temperature. StyleLite, substrate and the liner should be stored under the same environmental conditions to equalise for at least 12 hours prior to lamination.



**CAUTION** - Correct handling and safety procedures should be followed at all times.



**NOTE** - Large scale lamination projects should be undertaken by specialist lamination providers.



**WARNING** - Do not use PVC edge banding, solvent based adhesives or aggressive solvent based cleaners at any time.

## StyleLite® Lamination Methods

### HAND LAMINATION



1. Using a suitable panel saw, cut StyleLite®, substrate and backing panel slightly oversize.

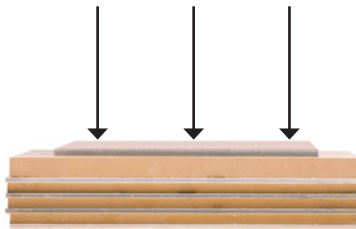


2. Ensure substrate and StyleLite sheet are free from dust and debris. Mix adhesive as directed by the manufacturer.



3. Apply adhesive using roller, spray or 2mm notched trowel.

40 lbs / 3 ft



4. Laminate the 3 materials and press for a minimum of 4 hours with a moderate weight spread evenly across the panels. Overnight pressing is ideal.



5. Trim laminated panels to final size using a plane or router.



### EDGE BANDING

Leave the peel coat in place and apply edge banding in normal manner. Use mineral spirits sparingly to clean off any excess adhesive. Take care when finishing the edge to avoid gouging the StyleLite surface.

For thicker panels, StyleLite can be sawn into strips and used as edge banding either before or after lamination, depending on the finish appearance required.

We recommend scuffing the rear surface of StyleLite strips for use as edge banding to ensure a reliable bond.

Refer to Guide 3 for more detail.



**WARNING** - Do not use PVC edge banding, solvent based adhesives or aggressive solvent based cleaners at any time.

